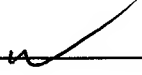


Date: Wednesday, 3/14/2007 12:25:14 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 31188		
Estimate Number	: 11123		
P.O. Number	: N/A	Part Number	: D2460
This Issue	: 3/14/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2460 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: D
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: 	Due Date	: 3/30/2007
Checked & Approved By	: _____	Qty:	4 Um: Each
Comment	: Est Rev: F Added Finish as per Rev D 05-11-30 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D2244116	Step Extrusion
-----	----------	----------------



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
.5	D2244	Step Extrusion	

Charital

links -> please see me about

323404 = 1 used scrap
323216 = 3



P.E. 07.03.20

4

2.0	D23381	End Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number
1	D2338-1

Description	Batch No.
End cap	

*3 31209 = 2 **
*316854 = 2 **

4

3.0	D23382	End Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number
1	D2338-2

Description	Batch No.
End cap	

*3 31210 = 2 **
316855 = 2

P.E. 07.03.20

4

4.0	D2459	204 Step Lug
-----	-------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number
1	D2459

Description	Batch No.
Lug	

321812 = 2
331211 = 2

P.E. 07.03.20

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action* Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 31188

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 per Dwg. D2460

2-Weld per Dwg. D2460

A/R Alum rod

Batch:

M100237
M100225

3-Deburr

PE-07.03.22 SEE MB PRIOR WELDING
D2338-1/-2 TO D2244-48.8
PE-07.03.22
PE-07.03.22

6.0

QC 15/9

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK inspect weld

07/03/22 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SS (07-03-22 (4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 07/03/22 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per dwg D2460

Batch: M 105480

a.m 07/03/26 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

PE 7/3/27 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

\$:

Identify and Stock

Location: _____

PPP D204-618-011 7/3/27 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/03/22	6.0	Qc 5/9	AA	07/03/22	4		AA 07/03/22	
	6.1	Chemical Conversion Coat	AA	07/03/22	4			
	6.2	Qc 3	FF	07/03/22	4			
	6.3	large fab. deburr and bevel left end for welding / weld as per dwg	AA	07-03-22	4			
	6.4	Qc 5/9	AA	07/03/23	4			
All perm. change								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 31188

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

D0703128

Job Completion



U 0703-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

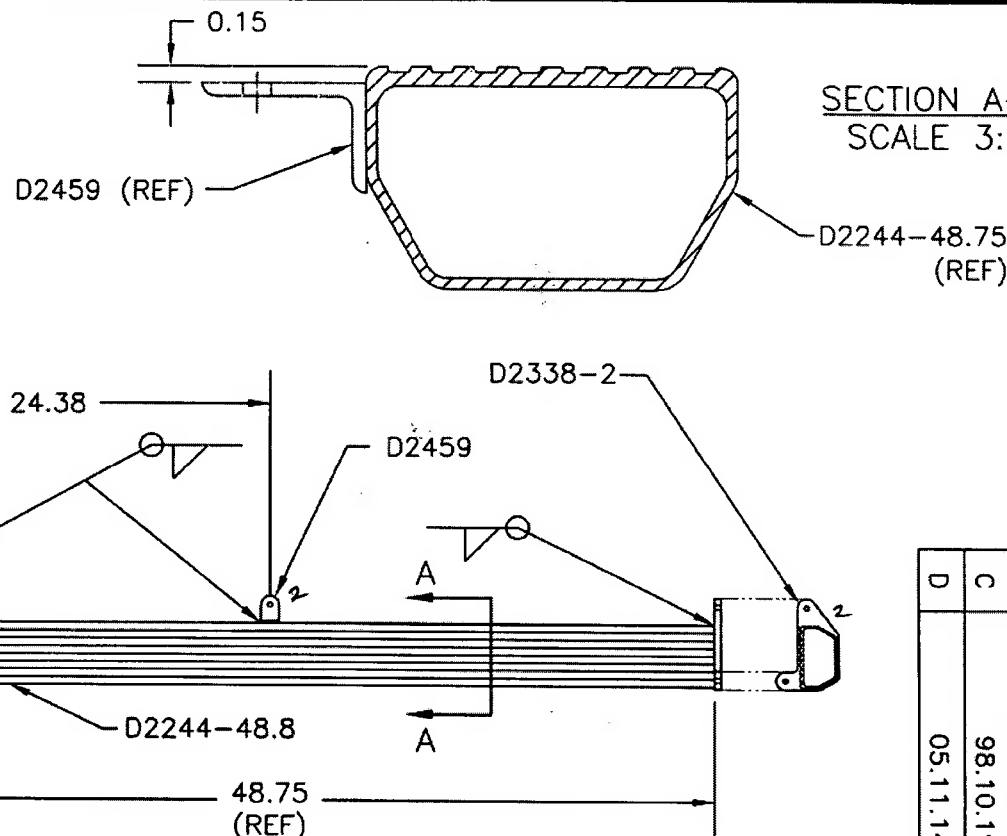
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		PH		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. 0
				D2460	SHEET 1 OF 1
DATE	05.11.14	TITLE		STEP WELDMENT ASSEMBLY	
		SCALE		1:10	
A	95.01.25	NEW ISSUE			
B	96.03.29	CHANGE END PLATES			
C	98.10.19	ADDED SECTION A-A (TSR A915)			
D	05.11.14	UPDATE FINISHING NOTES			

SECTION A-A
SCALE 3:5



RELEASED
05/11/28

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31188

D2460 STEP WELDMENT ASSEMBLY PARTS LIST

P/N	DESCRIPTION	QTY
D2460	STEP WELDMENT ASSEMBLY	X
D2244-48.8	EXTRUSION*	1
D2338-1	ENDPLATE	1
D2338-2	ENDPLATE	1
D2459	ANGLE	1

*cut per drawing

D2460 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID TOP SURFACE TO BOTTOM OF
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED